

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024631**Date Inspected:** 05-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Vikram Singh was present during the times noted above for observations relative to the work being performed at ZPMC.

WELDING

OBG Bay 14

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3160-001-018 located on Deck Panel Diaphragm to Deck Plate of the OBG Segment 14E. The welder is identified as 066461. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3163-001-221 located on Deck Panel Diaphragm to Deck Plate of the OBG Segment 14E. The welder is identified as 066326. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2212-Tc-U4b-FCM-1.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3167-001-058 located on Deck Panel Diaphragm to LD connection plate of the OBG Segment 14E. The welder is identified as 066439. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as DP3163-001-164 located on Deck Panel Diaphragm to LD connection plate of the OBG Segment 14E. The welder is identified as 050969. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20223.

This QA Inspector observed the welding operation per the SMAW process on a weld joint identified as Seg3013P-058 located on K-Plate of the OBG Segment 13AW. The welder is identified as 037748. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-3G (3F)-FCM-Repair and B-WR20172.

Flux Cored Arc Welding (FCAW)

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3160-001-061 located on Deck Panel Diaphragm to Deck Plate of the OBG Segment 14E. The welder is identified as 068592. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3160-001-391 located on Deck Panel Diaphragm to U-Rib of the OBG Segment 14E. The welder is identified as 206623. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-B-T-2133-ESAB.

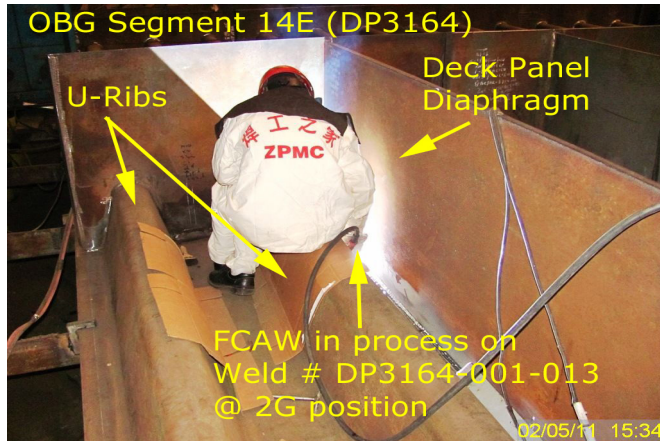
This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as Seg3015C-010 located on Floor Beam Flange to deck panel diaphragm of the OBG Segment 13CW. The welder is identified as 201583. ZPMC Quality Control (QC) is identified as Mr. Zhang Lin. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB.

This QA Inspector observed the welding operation per the FCAW process on a weld joint identified as DP3164-001-013 located on Deck Panel Diaphragm to Deck Plate of the OBG Segment 14E. The welder is identified as 068920. AB/F Quality Control (QC) is identified as Mr. Zheng Peng. The welding variables recorded by QC appeared to comply with WPS-B-T-2232-ESAB. See attached Photo

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Singh,Vikram	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
